

Work Order ID 69956

Wednesday, May 25, 2011 9:56:00 AM

Page 1

Item ID: D206-667-107BL

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Mid Fwd, Blue

Start Date: 5/25/2011 Start Qty: 1.00

Required Date: 5/27/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D206-667

D

100

0.00

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D206-667-107

205

0.00

SprayPaint

Memo

0.00

Spray Painting

PULL

1 X D206-667-107BL B65369

-REMOVE CLAMPS MS21920-20

AND DISCARD - DO NOT REMOVE SUPPORTS

-REMOVE ALL PAINT USING LINE MATE, DO NOT REMOVE ANY

MATERIAL

-RE-ALODINE

JCL 11-6-3

11-05-31

Work Order ID 69956

Wednesday, May 25, 2011 9:56:00 AM

Page 2

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Reference:

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Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

206

0.00



0.00

QC

Memo

Quality Control

RE-INSPECT

210

0.00



0.00

SprayPaint

SprayPaint

Memo

Spray Painting

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube as per QSI 005 4.2

DEFLEET BLUE B 115985

DEFLEET CLEAR B 117101

PRIME:

Start Time: 8:00

Finish Time: 8:00

PAINT:

Start Time: 1:00

Finish Time: 2:00

25 11-05-31

Work Order ID 69956

Wednesday, May 25, 2011 9:56:00 AM

Page 3

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Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC14- Inspect Spray Paint

0.00

QC

Memo

0.00

Quality Control

Wrap in plastic bag to protect from scratches

230

Crosstubes

0.00

Crosstubes

Memo

0.00

Crosstubes

1-Install NEW clamps as per Dwg D206-667-147. Torque clamps to 80-100 in lb

240

QCS- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Re inspect to Rev A Dwg.



Cust Item ID:

Customer:



FL

11-06-01

Pto

x1

Dart Aerospace Ltd

W/O: <u>69956</u>		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/06/01	230	install new 3525-063-395 rubber cushions B 65361 x4	BT	11/06/01	x4	11/06/01	S 11/06/03

Part No: D206-667-107BL PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69956

Wednesday, May 25, 2011 9:56:00 AM



Page 4

Item ID: D206-667-107BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Mid Fwd, Blue

Start Date: 5/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/27/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/6/3

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/26/03

76

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-667-107

Location:

PPP Rev:

DND KJ

10/1/13

Work Order ID 69956

Wednesday, May 25, 2011 9:56:00 AM

Page 5

Item ID: D206-667-107BL

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Start Date: 5/25/2011 Start Qty: 1.00

Required Date: 5/27/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u16187

u1.06.08

Picklist Print

Wednesday, May 25, 2011 9:55:56 AM

Work Order ID: 69956

Parent Item: D206-667-107BL

Parent Item Name: Crosstube Mid Fwd, Blue



Start Date: 5/25/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: revA 11.01.13 New Issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-667-107BL		Manufactured	No				Each	0.0000		1			
Crosstube Mid Fwd, Blue													
MS21920-20		Purchased	No				Each	64.0000		4			
Clamp (per MIL-DTL-8783C)													

Location

Loc Qty

Loc Code

LG050

64

116799

18

117279

46

x4

B 65369



IT

11-05-31



IT

11-06-01

Picklist Print

Friday, June 03, 2011 7:42:05 AM

Page 1

Work Order ID: 69956

Parent Item: D206-667-107BL

Parent Item Name: Crosstube Mid Fwd. Blue

Start Date: 5/25/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: revA 11.01.13 New Issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN5-30A Purchased No



BOLT

Location

Loc Qty

Loc Code

ST339

87

116003

37

117514

50

Each

220.0000

AN5-32A Purchased No



Bolt

Location

Loc Qty

Loc Code

ST340

220

115589

35

117161

50

117514

50

117688

25

117872

60

Each

253.0000

AN5-7A Purchased No



Bolt

Location

Loc Qty

Loc Code

ST337

253

116516

3

117313

100

117441

150

Each

0.0000

AN960JD516 NAS1149D0563J Purchased No



Washer

Handwritten: 24, 4, 5

Handwritten: 24, 4, 5

Handwritten: 210, 10, 11/6/38

Handwritten: 218, 18, 11/729, 11/6/38

Picklist Print

Friday, June 03, 2011 7:42:05 AM

Page 2

Work Order ID: 69956

Parent Item: D206-667-107BL

Parent Item Name: Crosstube Mid Fwd. Blue

Start Date: 5/25/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00

AN970-4

Purchased

No

Each

467.0000



Washer



Handwritten: 717, 12, and a large 'S' with a checkmark.

Location

Loc Qty

Loc Code

ST342

400

117795

400

ST344

14

115936

14

ST349

53

116900

3

117317

50

MS21042L5

Purchased

No

Each

1,152.000



Nut



Handwritten: x4, 11, 11/6/3, and a large 'S' with a checkmark.

Location

Loc Qty

Loc Code

ST300

1152

116105

192

116548

260

117441

500

117591

100

117611

100

MS21920-20

Purchased

No

Each

60.0000



Clamp (per MIL-DTL-8783C)



Handwritten: 4

Location

Loc Qty

Loc Code

LG050

60

116799

14

117279

46

Handwritten: see pg. 1 and a checkmark.

Friday, June 03, 2011 7:42:06 AM

Shop Packet Print

Page 2

5.2 MID-HEIGHT CROSSTUBES

Item	Qty -107	Qty -207	Part Number	Description
	X		D206-667-107	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 MID FWD
		X	D206-667-207	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 MID AFT
7	1		D206-667-147	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 MID FWD
8		1	D206-667-247	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 MID AFT
10	*2		D2891-1	SUPPORT
11		*2	D2892-1	SUPPORT
13	*4		D3595-063-395	RUBBER CUSHION
14		*4	D3595-063-450	RUBBER CUSHION
16	*4		MS21920-20	CLAMP
17		*4	MS21920-22	CLAMP
19	4		AN5-32A	BOLT
20		4	AN5-34A	BOLT
21	4	4	MS21042L5	NUT (OR MS21042-5)
22	8	8	NAS1149C0563J	WASHER (OR AN950JD516)
40	*2	*2	D2873-043	NUT PLATE
41	*2	*2	D2873-045	NUT PLATE
44	10		AN5-7A	BOLT
45		10	AN5-10A	BOLT
46	4		AN5-30A	BOLT
47		4	AN5-32A	BOLT
48	12		AN970-4	WASHER (OPTIONAL)
50	10	10	NAS1149C0563J	WASHER (OR AN960JD516)

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-147/-247 ASSEMBLIES ABOVE

Location/Lot Activity

Wednesday, May 25, 2011 7:08:40 AM

Page 1 of 1

Criteria :	All Items	All Locations	Lot: 65369	All Transaction Types	All Dates	Report on Locations & Lots				
Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date	Extended Cost
Issue	D206-667-107BL / Crosstube Mid Fwd, Blue	Main Warehouse FG	RD1373JAN	FAUT01		1.0000		1.0000		
					1/24/2011	-1.0000	65369	-1.0000		(\$2,504.99)
								-1.0000		(\$2,504.99)
WIP Receipt	D206-667-107BL / Crosstube Mid Fwd, Blue	Main Warehouse FG	65369	FAUT01		0.0000		0.0000		
					1/24/2011	1.0000	65369	1.0000		\$2,504.99
								1.0000		\$2,504.99

64956

Item	Qty -147	Part Number	Description
1	X	D206-667-147	CROSSTUBE ASSEMBLY (206L MID FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 99.84±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-147" AND BATCH NUMBER ON
INSIDE OF CLIFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 15.0 lbs (-507 = 12.84)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI
015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE
THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS
ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

69956

RELEASED
2011-05-23
JMT

A	NEW ISSUE	CP	10.11.23
REV.	DESCRIPTION	BY	DATE
DESIGN:	97		
DRAWN	97		
CHECKED			
MFG. APPR.			
DE APPR.			
DATE	10.12.23		

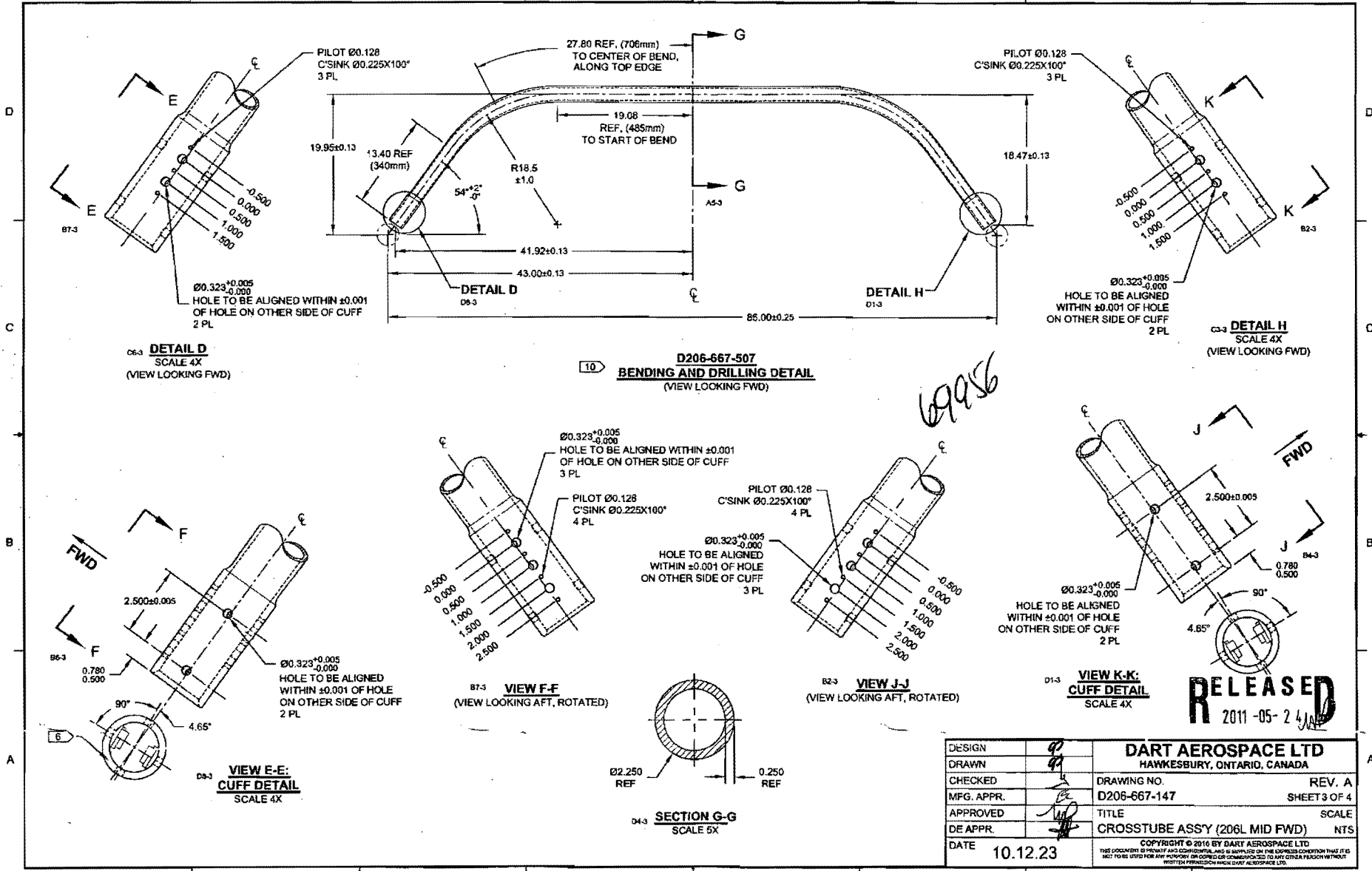
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D206-667-147
TITLE CROSSTUBE ASSY (206L MID FWD)

REV. A
SHEET 1 OF 4
SCALE NTS

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8 7 6 5 4 3 2 1

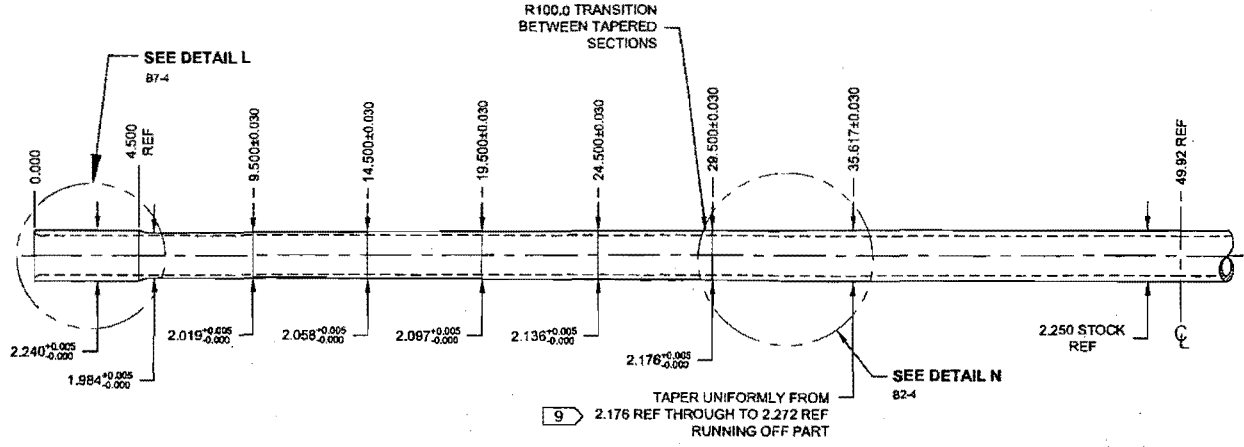


RELEASED
2011-05-24

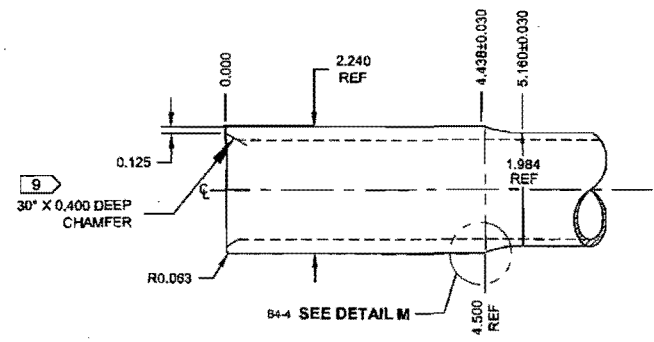
DESIGN	<i>99</i>	DART AEROSPACE LTD	
DRAWN	<i>99</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D206-667-147	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE ASSY (206L MID FWD)	NTS
DATE	10.12.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

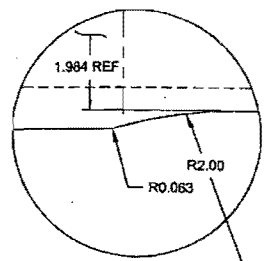
D
C
B
A



TURNING DETAIL

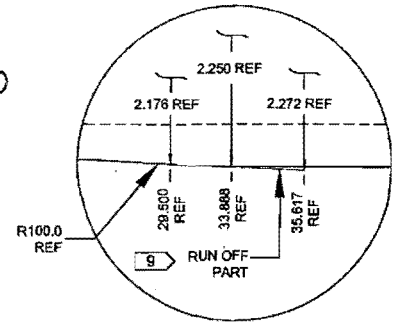


**DETAIL L:
CROSSTUBE CUFF**
D7-4
NOT TO SCALE



**DETAIL M:
CUFF TRANSITION**
A8-4
NOT TO SCALE

60956



**DETAIL N:
TAPER RUN-OFF**
C4-4
NOT TO SCALE

RELEASED
2011-05-23

DESIGN	9	DART AEROSPACE LTD	
DRAWN	9	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D206-667-147	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASSY (206L MID FWD)	NTS
DATE	10.12.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D206-667
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5.2 MID-HEIGHT CROSSTUBES

Item	Qty -107	Qty -207	Part Number	Description
	X		D206-667-107	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 MID FWD
		X	D206-667-207	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 MID AFT
7	1		D206-667-147	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 MID FWD
8		1	D206-667-247	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 MID AFT
10	*2		D2891-1	SUPPORT
11		*2	D2892-1	SUPPORT
13	*4		D3595-063-395	RUBBER CUSHION
14		*4	D3595-063-450	RUBBER CUSHION
16	*4		MS21920-20	CLAMP
17		*4	MS21920-22	CLAMP
19	4		AN5-32A	BOLT
20		4	AN5-34A	BOLT
21	4	4	MS21042L5	NUT (OR MS21042-5)
22	8	8	NAS1149C0563J	WASHER (OR AN950JD516)
40	*2	*2	D2873-043	NUT PLATE
41	*2	*2	D2873-045	NUT PLATE
44	10		AN5-7A	BOLT
45		10	AN5-10A	BOLT
46	4		AN5-30A	BOLT
47		4	AN5-32A	BOLT
48	12		AN970-4	WASHER (OPTIONAL)
50	10	10	NAS1149C0563J	WASHER (OR AN960JD516)

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-147/-247 ASSEMBLIES ABOVE

Work Order ID 65369

PRELIMINARY ISSUE

Page 1

January 13, 2011 1:05:08 PM

Item ID: D206-667-107BL

Accept

Setup Start

Revision ID: PRELIM

Stop

Item Name: 206 Fwd Crosstube

Start Date: 1/13/11 Start Qty: 1.00

Cust Item ID:

Required Date: 1/20/11 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D206-667-107

DP 11-01-24

110

0.00



Pick Kit

Packaging

Packaging

Memo

0.00

Packaging

DP 11-1-12

120

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D206-667-147 using CNC bender program

DP 11-1-12

Work Order ID 65369

January 13, 2011 1:05:08 PM

Page 2

Item ID: D206-667-107BL

Accept

Setup Start

Revision ID: PRELIM

Stop

Item Name: 206 Fwd Crosstube

Start Date: 1/13/11 Start Qty: 1.00

Cust Item ID:

Required Date: 1/20/11 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC15- Crosstube Dimensional Check

0.00



QC

Memo

0.00

P 11.01.17

Quality Control

Work Order ID 65369

January 13, 2011 1:05:08 PM



Page 3

Item ID: D206-667-107BL

Accept



Setup Start

Revision ID: PRELIM

Stop

Item Name: 206 Fwd Crosstube.



Start Date: 1/13/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/20/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1-Drill holes & ream using drill Jig DT & DT as per Dwg D206-667-147. Drill all (3) top holes.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT & DT as per Dwg D206-667-147. Drill only the top (2) holes.

5-Drill pilot holes as per Dwg D206-667-147. Drill only the top (2) holes.

6-Drill Fwd rivet holes using drill Jig DT as per Dwg D206-667-147. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT as per Dwg D206-667-147.

8-C'sink holes as per Dwg D206-667-147. Allow rivet to sit below surface to compensate for paint.

9-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-147. Inside of Cuff (Do not engrave on outside of tube)

10-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-147

SAS

11-01-12

11-1-12

Work Order ID 65369

January 13, 2011 1:05:25 PM



Page 4

Item ID: D206-667-107BL

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: 206 Fwd Crosstube

Start Date: 1/13/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/20/11 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFXtube	Crosstubes Chemical Conversion	0.00							
Hand Finishing Crosstubes	Memo	0.00							
160 QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00							
170 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

DD

11-1-13

BR ① M-01-17

*- inspect to spec
Qty only
8/10/12*

Work Order ID 65369

January 13, 2011 1:05:25 PM

Page 5



Item ID: D206-667-107BL

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: 206 Fwd Crosstube

Start Date: 1/13/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/20/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Outsource process - NDT per QSI038 4.1	0.00							
Outsource2	Memo	0.00							
Outsource process - NDT	CROSSTUBES								
190 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Ensure copy of NDT results attached to work order.								
200 	QCS- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

P10:13298

CY 11/10/11 7 ①

Pc 11/14/11 ①

ml - 11 01 18 ①

Work Order ID 65369

January 13, 2011 1:05:26 PM



Page 6

Item ID: D206-667-107BL

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: 206 Fwd Crosstube

Start Date: 1/13/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/20/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

0.00



SprayPaint

SprayPaint

Memo

0.00

Spray Painting

1-Prime inside and outside crosstube as per QSI 005 4.2 ✓

2-Paint outside crosstube with ~~White~~ ^{Blue} Incon as per QSI 005 4.2 X

PRIME:

Start Time: _____

Finish Time: _____

PAINT:

Start Time: _____

Finish Time: _____

Primer: 115967

Paint: 115509

Clear: 115949

220

0.00



QC14- Inspect Spray Paint

QC

Memo

0.00

Quality Control

Wrap in plastic bag to protect from scratches

1/18-01-19

Work Order ID 65369

January 13, 2011 1:05:54 PM



Page 7

Item ID: D206-667-107BL

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: 206 Fwd Crosstube

Start Date: 1/13/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/20/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

0.00



Crosstubes

Crosstubes

Memo

0.00

1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note: (2) Aft holes should be facing up.
A/R Magnobond 6398: 115580 exp. 07/2011

2-Install supports and clamps as per Dwg D206-667-147. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-147. Touch-up rivet heads with Imron paint.

M/11/01/21

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11-01-20

Work Order ID 65369

January 13, 2011 1:05:54 PM



Page 8

Item ID: D206-667-107BL

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: 206 Fwd Crosstube

Start Date: 1/13/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/20/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
270		0.00							
Packaging	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-667-107								
	Location: 33								
	PPP Rev: _____								

Not Required

B69956 DJ for SA 11/1/24

Work Order ID 65369

January 13, 2011 1:05:59 PM



Page 9

Item ID: D206-667-107BL

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: 206 Fwd Crosstube

Start Date: 1/13/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/20/11 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

RD 1373JAN

*HA 11/6/8
(see B69956)*

*MF
11-01-24*

POSITIVE RECALL

EFFECTIVE *11/13* AUTH *[Signature]*

RELEASED *[Signature]* DATE *11/05/25*

Picklist Print

January 13, 2011 1:05:05 PM

Page 1

Work Order ID: 65369

Parent Item: D206-667-107BL

Parent Item Name: 206 Fwd Crosstube




Start Date: 1/13/11

Required Date: 1/20/11

Start Qty: 1.00

Required Qty: 1.00

Comments: revA 11.01.13 New Issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-30A  BOLT		Purchased	No				Each	100.0000	4	4		11/12/11	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST339			100						
				114941			50						
				116003			50						
AN5-32A  Bolt		Purchased	No				Each	226.0000	4	4		11/12/11	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST340			226						
				114405			16						
				115016			50						
				115108			50						
				115589			60						
				115698			50						
AN5-7A  Bolt		Purchased	No				Each	238.0000	10	10		11/12/11	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST337			238						
				113149			100						
				115936			38						
				116516			100						

Picklist Print

January 13, 2011 1:05:05 PM

Page 2

Work Order ID: 65369

Parent Item: D206-667-107BL

Parent Item Name: 206 Fwd Crosstube

Start Date: 1/13/11

Required Date: 1/20/11

Start Qty: 1.00

Required Qty: 1.00

AN960JD516 NAS1149D0563J Purchased

No

Each

34.0000

18

18



Washer

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

AN970-4

Purchased

No

Each

123.0000

12

12



Washer

Location

Loc Qty

Loc Code

ST344

100

115936

100

ST349

23

116081

23

Each

0.0000

1

1

D206-667-247TRN

Manufactured

No



Crosstube Ass'y

D2873-043

Manufactured

No



Nut Plate Assembly

Location

Loc Qty

Loc Code

LG

18

63497

18

ST

2

60981

2

January 13, 2011 1:05:06 PM

Shop Packet Print

Page 2

Picklist Print

January 13, 2011 1:05:06 PM

Page 3

Work Order ID: 65369

Parent Item: D206-667-107BL

Parent Item Name: 206 Fwd Crosstube

Start Date: 1/13/11

Required Date: 1/20/11

Start Qty: 1.00

Required Qty: 1.00

D2873-045

Manufactured No

Each

20.0000

2

2



Nut Plate Assembly

Location

Loc Qty

Loc Code

LG

20

60982

4

63498

16

D2891-1

Manufactured No

Each

51.0000

2

2



2.25 Support

Location

Loc Qty

Loc Code

LG

51

46159

1

50952

18

53773

20

62595

12

D3595-063-395

Manufactured No

Each

75.0000

4

4



RUBBER CUSHION

Location

Loc Qty

Loc Code

FP

10

44667

10

ST

65

63368

65

cut (4)0.063" X 3.95"

January 13, 2011 1:05:06 PM

Shop Packet Print

Page 3

Picklist Print

January 13, 2011 1:05:07 PM

Page 4

Work Order ID: 65369

Parent Item: D206-667-107BL

Parent Item Name: 206 Fwd Crosstube

Start Date: 1/13/11

Required Date: 1/20/11

Start Qty: 1.00

Required Qty: 1.00

MS20601-AD4W8

Purchased

No

Each

234.0000

14

14



RIVET

Location

Loc Qty

Loc Code

LG

130

115855

30

116119

100

ST322

104

112203

104

MS21042L5

Purchased

No

Each

1,353.000

4

4



Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1327

115156

5

115594

500

116104

126

116105

496

116548

200

MS21920-20

Purchased

No

Each

57.0000

4

4



Clamp (per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

LG

57

112624

2

114687

1

115057

4

115736

50

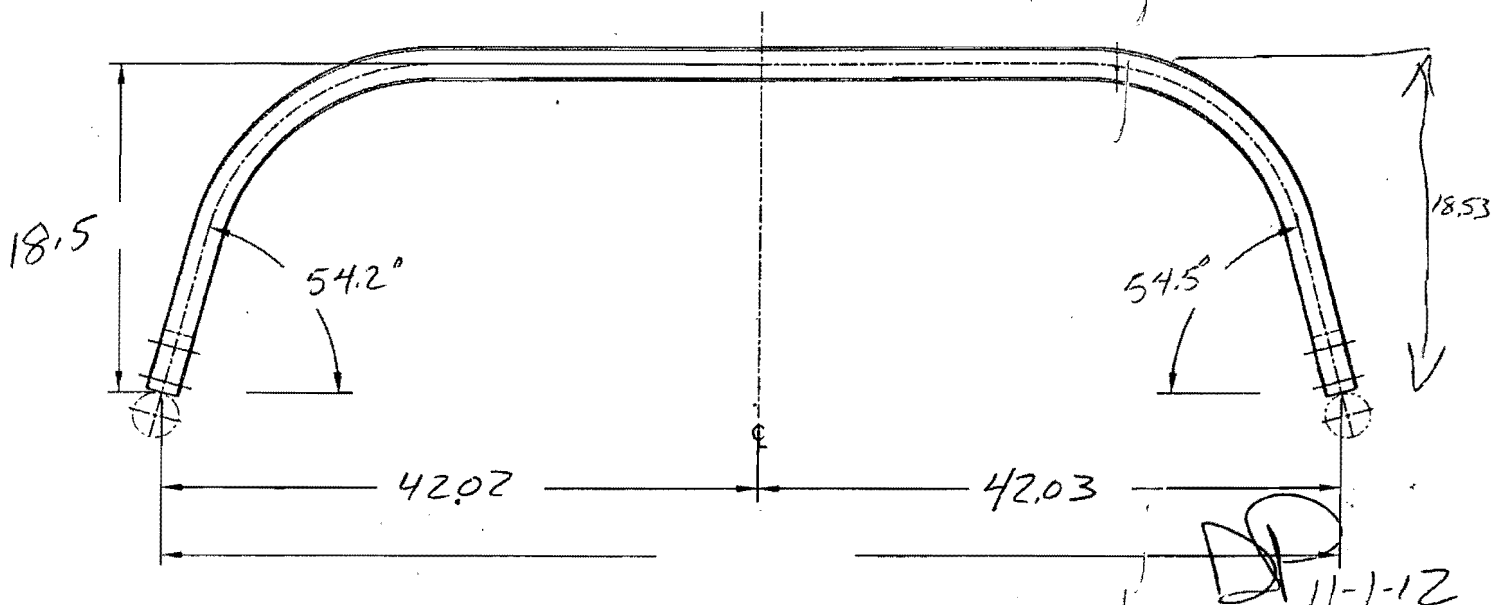
January 13, 2011 1:05:07 PM

Shop Packet Print

Page 4

DART AEROSPACE LTD		Work Order:	65369
Description: Crosstube <i>Preliminary</i>		Part Number:	D206-667-107
Inspection Dwg: D206-667-107	Rev: A	Page 1 of 1	

Required Dimension	Min	Max
Height		
1/2 Span		
Angle		
Total Span		



Comments

QC15 Inspection	<i>P</i>
Date	11.01.17

Rev	Date	Change	Revised by	Approved
		New Issue		

65369

Item	Qty -147	Part Number	Description
1	X	D206-667-147	CROSSTUBE ASSEMBLY (206L MID FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2881-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 99.84±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-147" AND BATCH NUMBER ON
INSIDE OF CLIFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 15.0 lbs (-507 = 12.84)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2881-1 SUPPORT USING 0.03" TO 0.08" THICK LAYER OF MAGNOBOND 6398 PER QSI
015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE
THE D2881-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS
ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

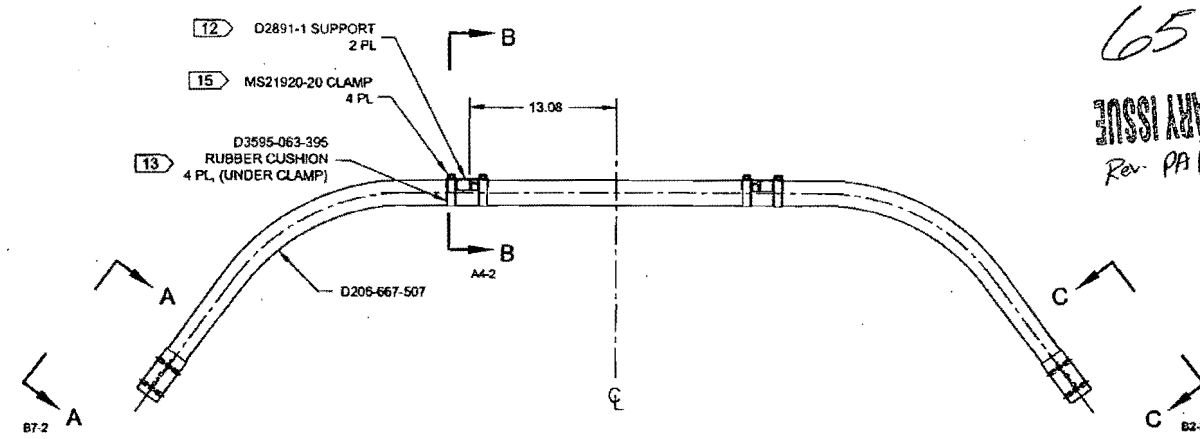
PRELIMINARY ISSUE

Rev A1 10.12.23

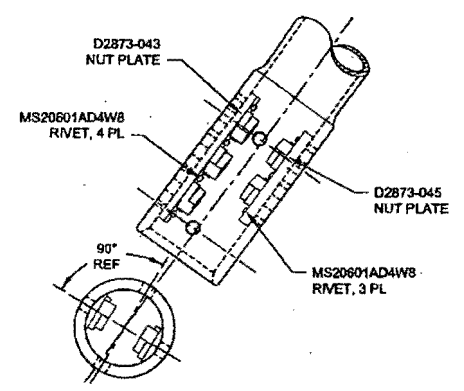
REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.12.23			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D206-667-147	REV. A
TITLE CROSSTUBE ASSY (206L MID FWD)	SCALE NTS
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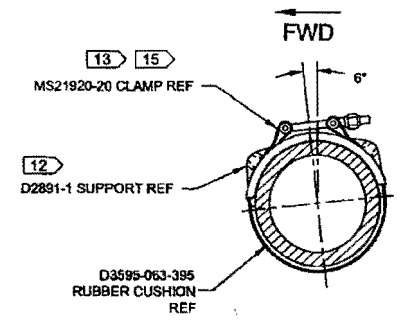
65369
 PRELIMINARY ISSUE
 Rev. PA1 11.01.06



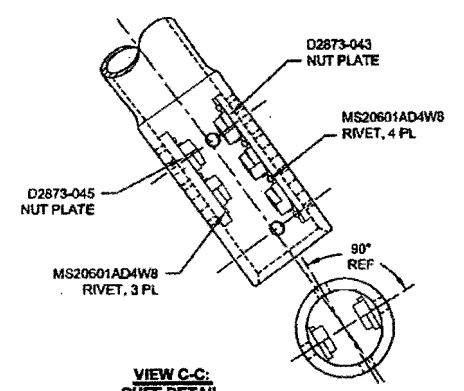
D206-667-147
ASSEMBLY DETAIL
 (VIEW LOOKING FWD)



VIEW A-A:
CUFF DETAIL
 SCALE 4X



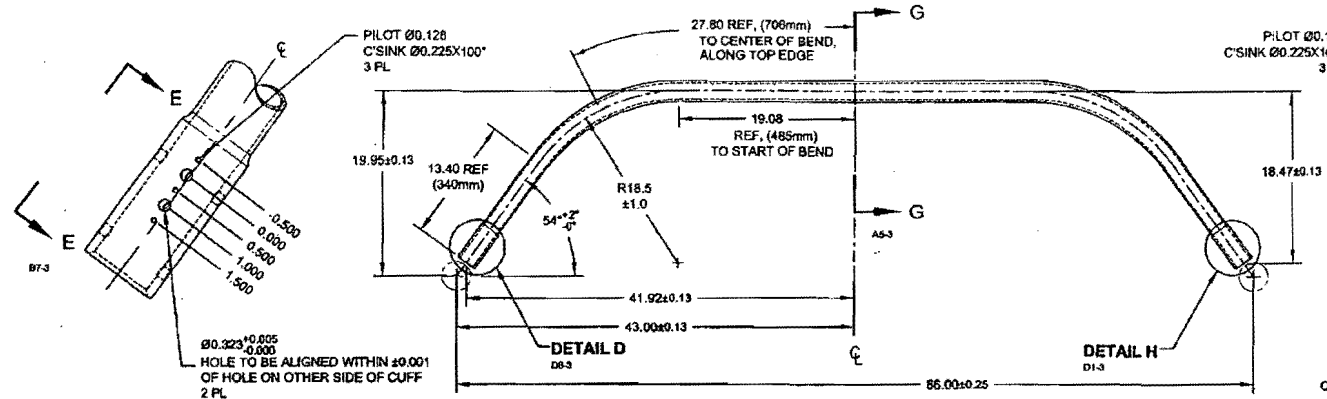
SECTION B-B
 SCALE 5X



VIEW C-C:
CUFF DETAIL
 SCALE 4X

DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	99		
CHECKED	1		
MFG. APPR.			DRAWING NO. REV. A
APPROVED			D206-667-147 SHEET 2 OF 4
DE APPR.			TITLE SCALE
DATE	10.12.23	CROSSTUBE ASSY (208L MID F.V.B.) NTS	
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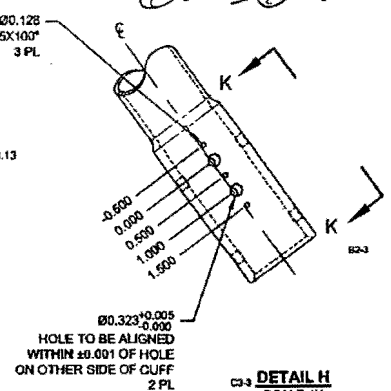
65369



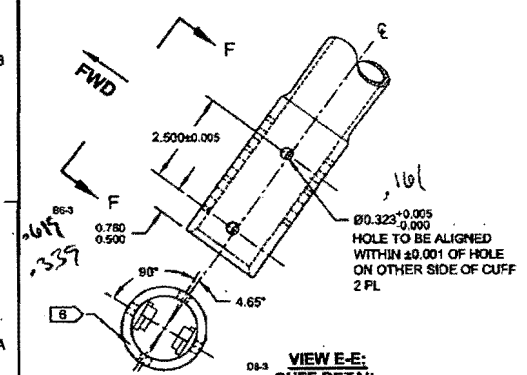
05-3 **DETAIL D**
SCALE 4X
(VIEW LOOKING FWD)

10 **D206-667-507**
BENDING AND DRILLING DETAIL
(VIEW LOOKING FWD)

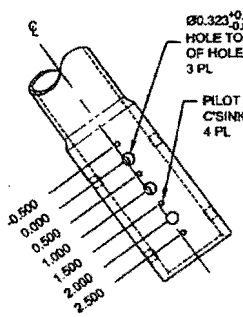
PRELIMINARY ISSUE
Rev FA1 01/01/06



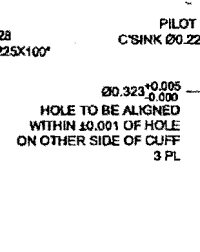
03-3 **DETAIL H**
SCALE 4X
(VIEW LOOKING FWD)



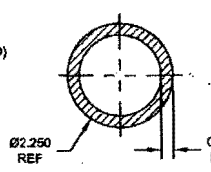
08-3 **VIEW E-E:**
CUFF DETAIL
SCALE 4X



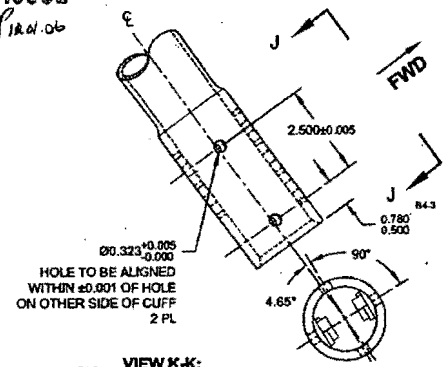
07-3 **VIEW F-F**
(VIEW LOOKING AFT, ROTATED)



02-3 **VIEW J-J**
(VIEW LOOKING AFT, ROTATED)



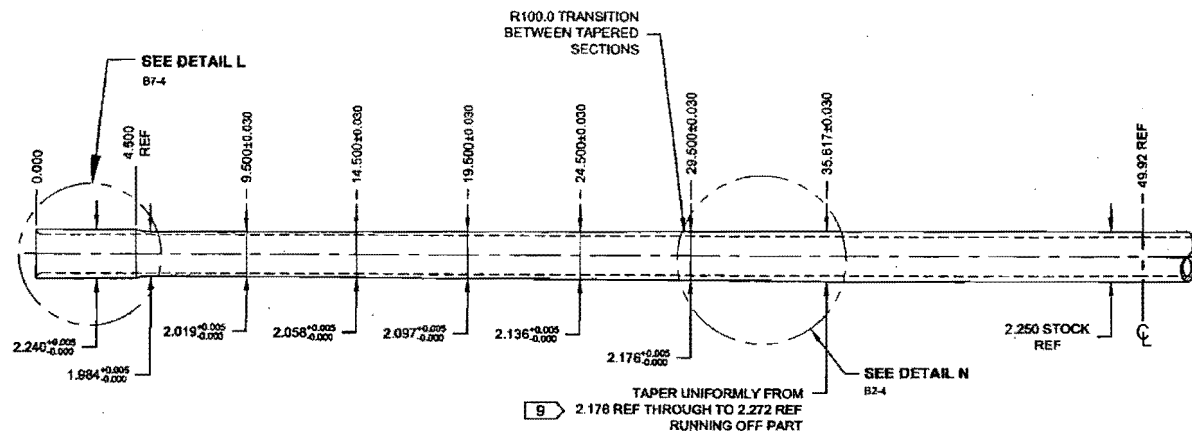
04-3 **SECTION G-G**
SCALE 5X



01-3 **VIEW K-K:**
CUFF DETAIL
SCALE 4X

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D206-667-147 SHEET 3 OF 4
APPROVED		TITLE SCALE
DE APPR.		CROSS-TUBE ASSY (206L MID FWD) NTS
DATE	10.12.23	COPYRIGHT © 2016 BY DART AEROSPACE LTD

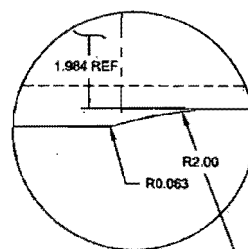
65369



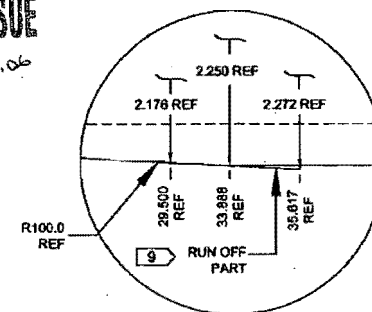
TURNING DETAIL

PRELIMINARY ISSUE

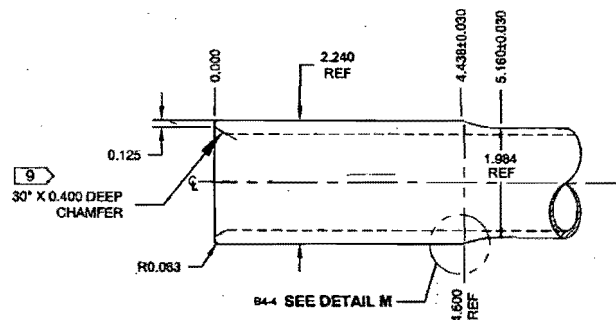
REV. PA1 11.01.06



**DETAIL M:
CUFF TRANSITION**
NOT TO SCALE



**DETAIL N:
TAPER RUN-OFF**
NOT TO SCALE



**DETAIL L:
CROSSTUBE CUFF**
NOT TO SCALE

DESIGN	97	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D206-667-147	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (206L MID FWD)	NTS
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LIQUID PENETRANT TEST REPORT

P- 05495

CLIENT DART AEROSPACE DATE JAN 17/2011 PAGE 1 OF 1
ATTENTION ANITA LACELLE / CHANTALE / IAN ACUREN JOB NO. 138-11-2015 TIME AM ☒ PM ☐
ADDRESS 1270, ABERDEN ST. POWO NO. 13298
HAWKESBURY, ON WORK LOCATION AS ADDRESS
ACCEPTANCE STD. ASTM 1417/631-038 REV./DATE 20005
PROJECT F.P.I ON 2 "Cross Tubes"
ITEM(S) EXAMINED SEE BELOW


JOB DESCRIPTION PROCEDURE NO. LT002 REV./DATE 2003 TECHNIQUE NO. LT-002 REV./DATE 2003
PART NO. MATERIAL Alcide Aluminium THICKNESS N/A
SCOPE PERFORMED A WET-FLUORESCENT LIQUID PENETRANT INSPECTION ON 100% OF THE EXTERNAL SURFACE

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
AMILY BRAND MAGNA FLUX BLACK LIGHT S/N B398 OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT 2L-67 MINIMUM DWELL TIME 10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER AS MINIMUM DRY TIME > 10 MIN. OTHER
DEVELOPER SKD-52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE FEB-05-2011
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/ 50°F ☒ 10°C/ 50°F TO 52°C/ 125°F ☐ > 52°C/ 125°F
RESULTS- ☐ METRIC ☒ IMPERIAL

1 Cross-Tube W.O. ID 65369
2 Cross-Tube W.O. ID 65370

NO REJECTABLE INDICATION WAS DETECTED
AS PER APPLICABLE STANDARD

"CROSS TUBE"

1 TEST ID: - D206-667-107BL
- D206-667-207BL
11-01-18

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacturing, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES
CLIENT REPRESENTATIVE Matt Murdoch PRINT Matt Murdoch SIGNATURE Matt Murdoch DTR # E-44834
TECHNICIAN (SIGNATURE): Yves Desrosiers REPORT REVIEWED BY:
NAME (PRINT): YVES DESROSIERS NAME INITIALS
1ST TECHNICIAN 2ND TECHNICIAN
CGSB LEVEL 2 SNT LEVEL 2 CGSB LEVEL SNT LEVEL
CGSB REG. NO. 3049 CGSB REG. NO.

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PT Sept 2005